


Date: Wednesday, 1/23/2008 11:32:37 AM
 User: Kim Johnston

Process Sheet

| | | |
|---|----------------------------------|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOUBLER | |
| Job Number : 36915 | | |
| Estimate Number : 13055 | | |
| P.O. Number : | Part Number : D36541 |  |
| This Issue : 1/23/2008 S.O. No. : | Drawing Number : D3654 REV.A U/R | |
| Prsht Rev. : NC | Project Number : N/A | |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A U/R | |
| Previous Run : 35899 | Material : | |
| Written By : | Due Date : 2/29/2008 | Qty: 2 Um: Each |
| Checked & Approved By : | | |
| Comment : Est Rev:A New Issue 07-10-29 DD verified by: EC | | |

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.3675 sf(s)/Unit Total : 0.7350 sf(s)
 304/316 SS sheet 16 ga (0.063" thick)
 Batch: 106653 IB 8-2-1

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3654
 Dwg Rev: A U/R
 Prog Rev: A U/R

IB 8-2-1



2-Deburr if necessary

IB 8-2-1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

56/2/09 (42) / 05-05-2009
ENGINEERING APPROVAL

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock
 Location: ST 115

AS 08/07/11 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36915

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.27
MP 8.27-16
POSITIVE RECALL

EFFECTIVE *08.1.31* AUTH *u*

RELEASED *u* DATE *8.27.07*

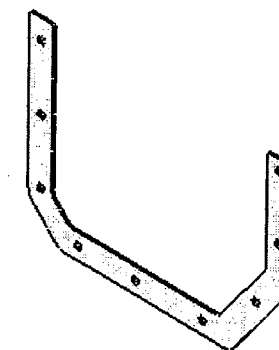
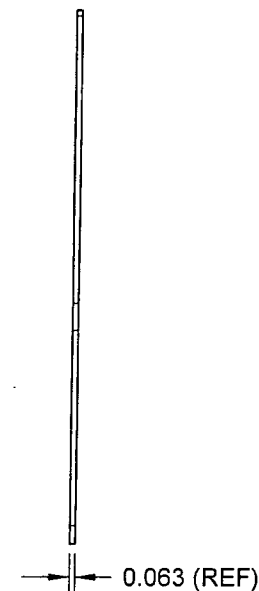
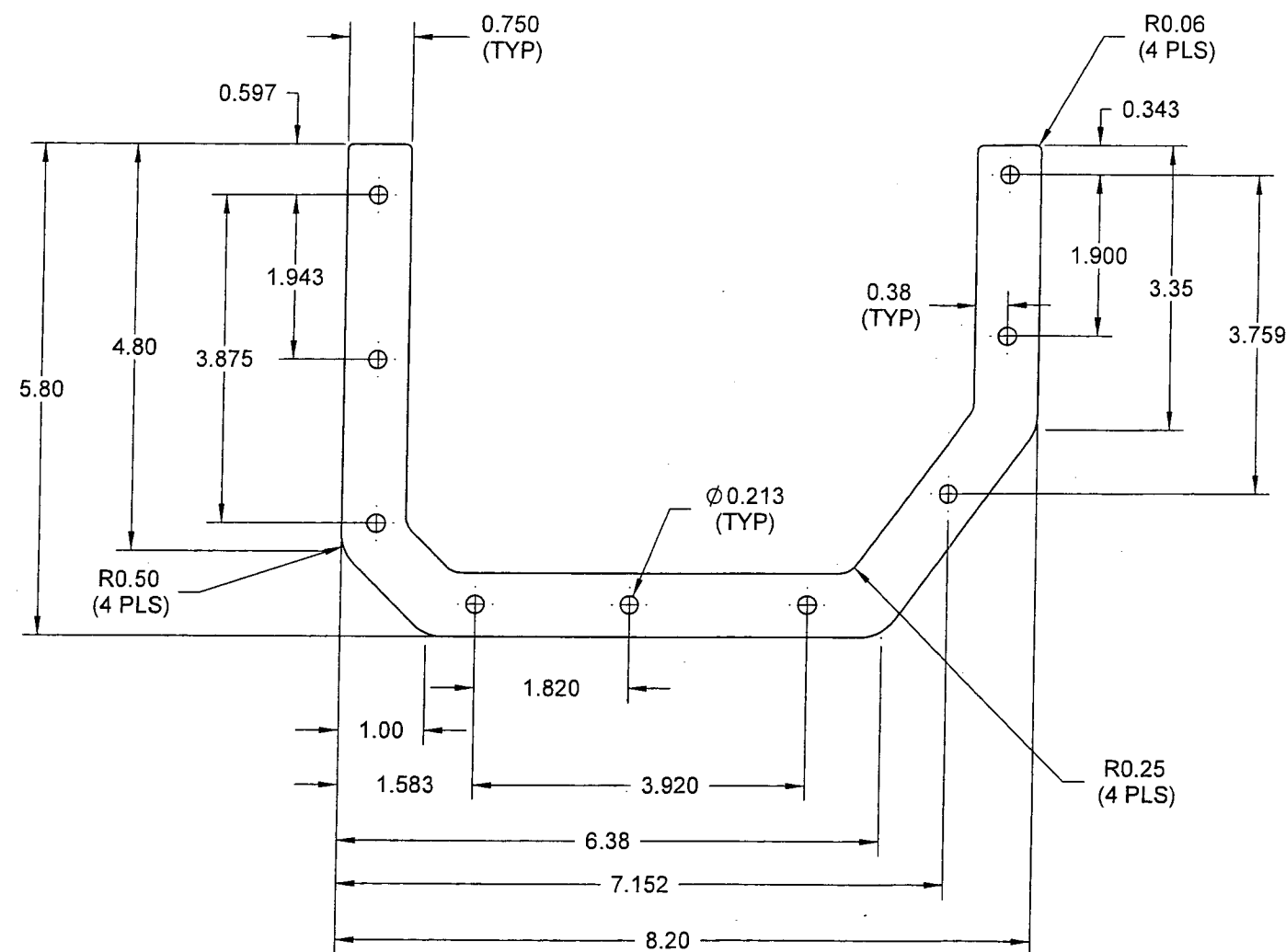
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3654-1 DOUBLER

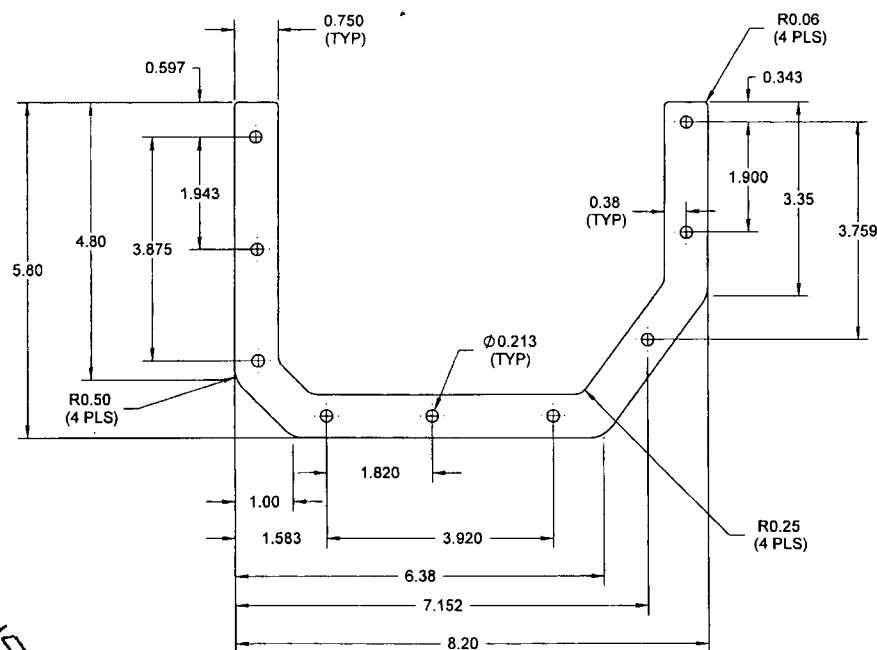
PRELIMINARY ISSUE

08-01-18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | RF | 07.11.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. A |
| MFG. APPR. | RF | D3654 | SHEET 1 OF 1 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | DOUBLER | 1:2 |
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D3654-1 DOUBLER

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| DRAWN | RF | | |
| CHECKED | UE | DRAWING NO. | REV. A |
| MFG. APPR. | 11/0 | D3654 | SHEET 1 OF 1 |
| APPROVED | 11/0 | TITLE | SCALE |
| DE APPR. | 11/0 | DOUBLER | 1:2 |
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